

Work Order ID 76563

76563

Page 1

November-16-11 3:40:29 PM

Item ID: D3016-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Frame Assembly
 Start Date: 16/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/12/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: M.L.S Date: 11/11/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3016	RevA / DEO A-1

100 Weld per dwg A/R 4130 rod Batch: M118875 0.00
100 Large Fab
 Memo 0.00
 1-Cut all tubes as per Dwg D3016
 2-Deburr
 3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597
 4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041
 5- Assemble brackets and gusset per dwg and weld

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC Memo 0.00
 Quality Control

Q 11-11-22 X
Y O Q 11-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S u l u l z z		(4) set			
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo Install paint screws on fitting ends START TIME: 8:20 OVEN TEMPERATURE: 320°F FINISH TIME: 8:50	0.00 0.00							1 X P m-l 11/11/23
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 BR 11-11-23

M 118484

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Revision ID:

Stop ***NS2***

Item Name: Seat Frame Assembly

Start Date: 16/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

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Picklist Print

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Work Order ID: 76563

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Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 16/11/2011

Required Date: 01/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049		Purchased	No			100	f	105.5500	4.3	4.526316			
M4130NT0 750W 049										**	EL 11-11-22		
4130 RD Tube .750 x.049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				105.55				4.52	
				117973				33.55					
				118772				72					
M4130NT0.500W.049		Purchased	No			100	f	40.9100	4.3	4.526316			
M4130NT0 500W 049										**	EL 11-11-22		
4130 RD Tube .500 x.049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT032				40.91				4.52	
				110740				40.91					
M4130NT1.000W.120		Purchased	No			100	f	72.4200	1.5	1.578947			
M4130NT1 000W 120										**	EL 11-11-22		
4130 RD Tube 1.00 x .120wall													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				72.42				1.57	
				117656				25					
				117973				47.42					
D3016-17		Manufactured	No			100	Each	32.0000	2	2			
D3016-17										**	EL 11-11-22		
Gusset													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				32					
				70872				20					
				70909				12					

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 16/11/2011

Required Date: 01/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13 Manufactured No

100 Each 8.0000 2 2

D3016-13

Bracket

**

11-11-22

Location

Loc Qty

Loc Code

WA

8

70015

8

2

D3016-15 Manufactured No

100 Each 9.0000 2 2

D3016-15

Gusset

**

11-11-22

Location

Loc Qty

Loc Code

WA

9

73541

9

2

D3020-1 Manufactured No

100 Each 10.0000 4 4

D3020-1

Fitting

**

11-11-22

Location

Loc Qty

Loc Code

WA

10

36713

1

70873

9

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 36563
11/11/19
M.C.S.
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DEO ATTACHED

RELEASED
01.05.30

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

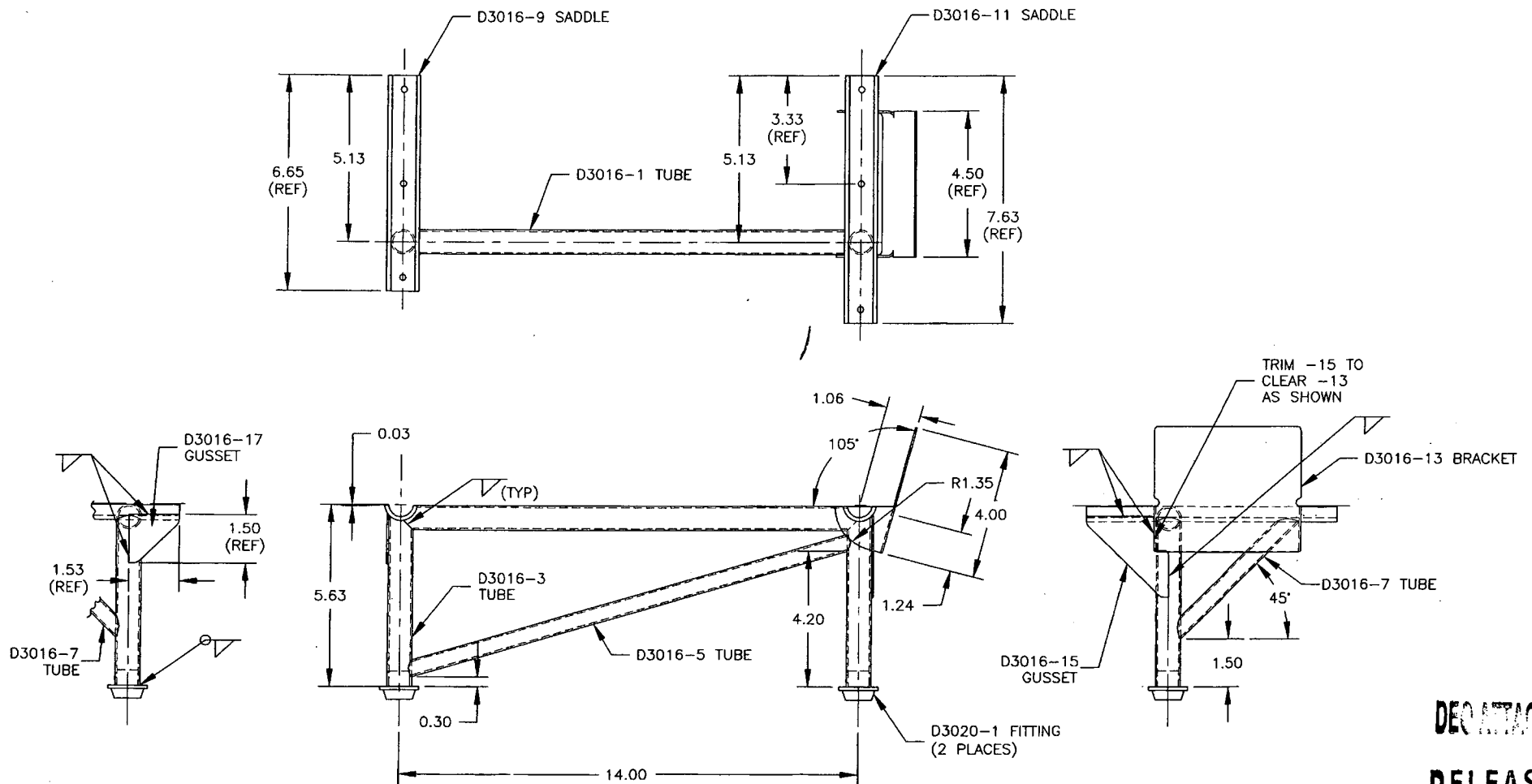
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D3016-041 SEAT FRAME ASSEMBLY



REQ ATTACHED
RELEASED
01.05.30

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DATE		01.05.18		DRAWING NO.	REV. A
				D3016	SHEET 2 OF 3
				TITLE	SCALE
				SEAT FRAME ASSEMBLY	1:3

W/O:		WORK ORDER CHANGES					
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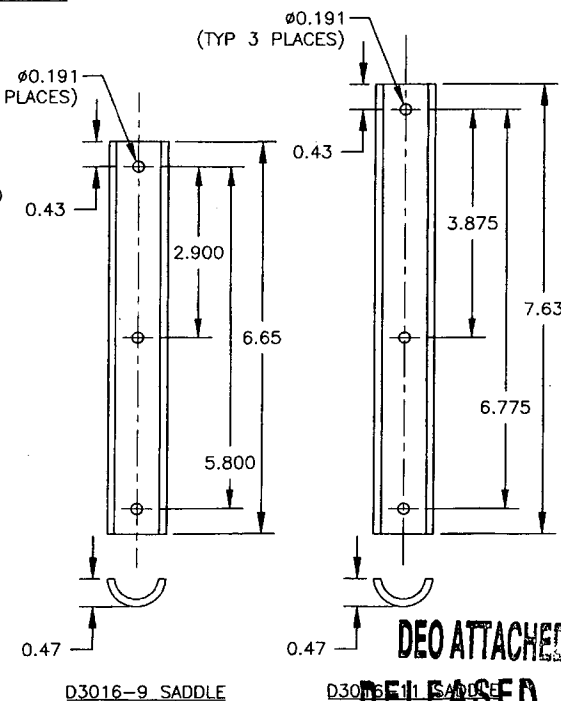
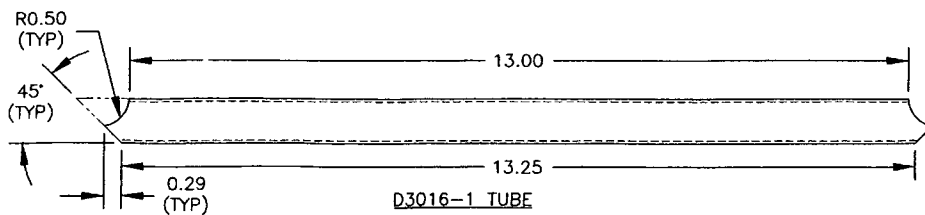
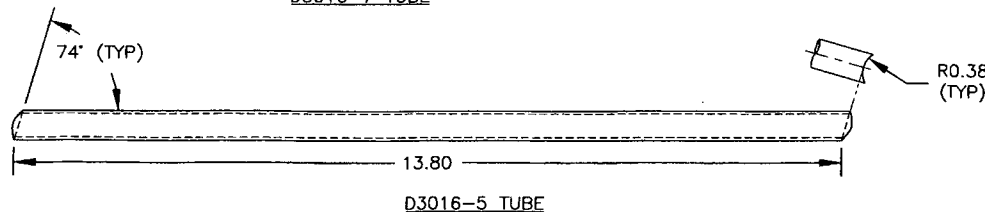
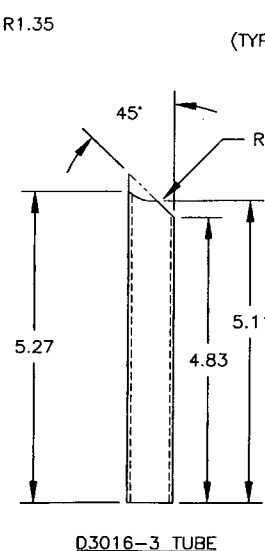
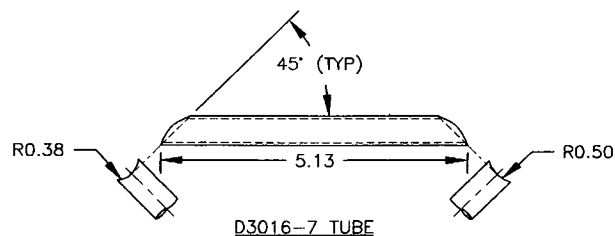
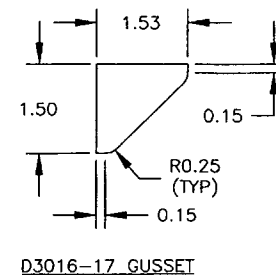
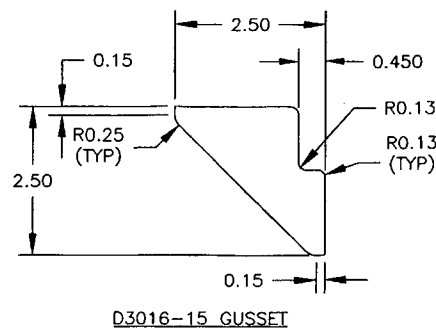
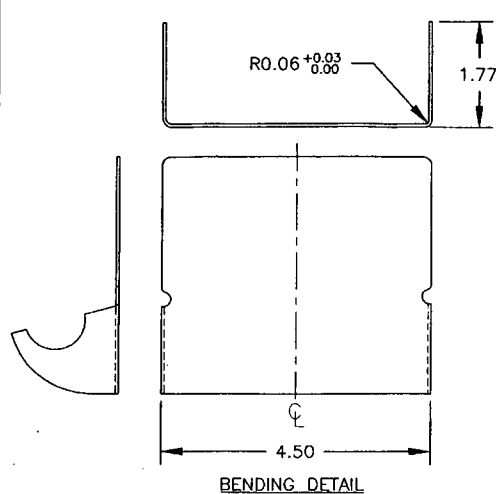
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DESIGN	CP	DRAWN BY	CP	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	D3016	SHEET 3 OF 3
		SCALE	1:2		

DEO ATTACHED
RELEASED
9.05.30

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29			

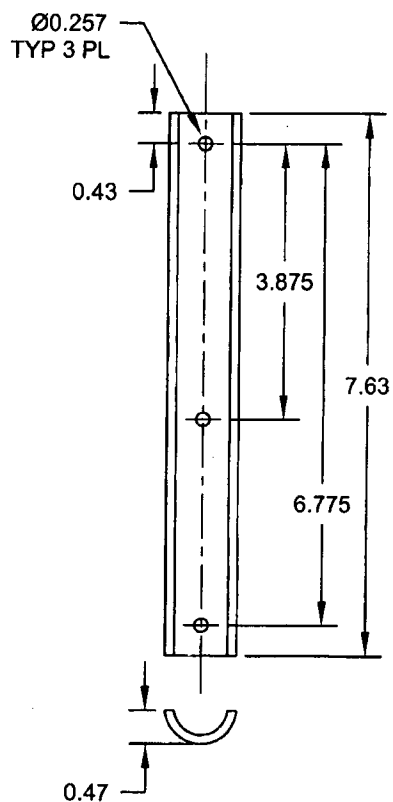
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

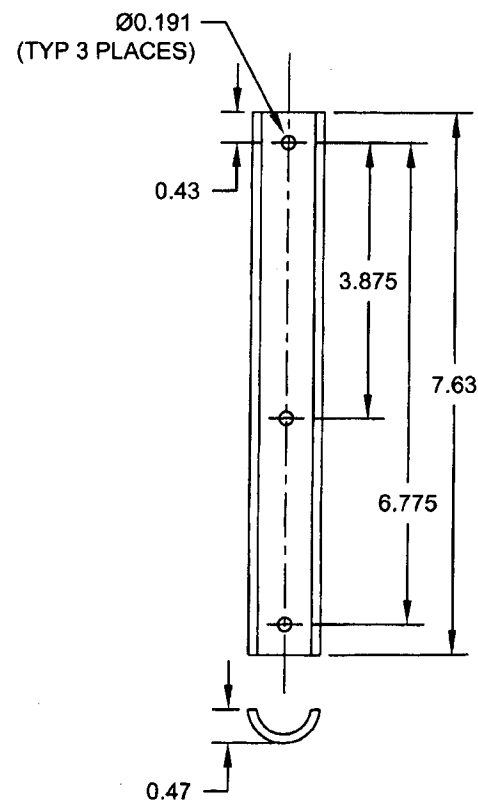
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

W/O:		WORK ORDER CHANGES					
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